

Date: Monday, 10/11/2008 10:42:24 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LH STEP ACTUATOR ASSEMBLY
 Job Number : 43267
 Estimate Number : 12758
 P.O. Number :
 This Issue : 10/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : 41232 000 001 001
 First Issue : / / Type : SMALL /MED FAB Drawing Number : 41232-000-001 REV A
 Previous Run : 43221 Project Number : N/A
 Material :
 Due Date : 01/12/2008 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JLD 08.11.10
 Comment : Est Rev:A New Issue 07-02-28 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile D412-763 & type labels per PPP 41232-000-001 CHG 002

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 AP0925ELBN BARBED ELBOW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BARBED ELBOW

Batch: 103727

4.0 AN960JD416 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M109249

5.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M10845

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0	AN423A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
Batch: M107378

7.0	MS3548993	GROMMET
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
GROMMET
Batch: M106168

8.0	AN960JD416L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
Washer
Batch: M109388

9.0	MS24665151	Cotter Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Cotter Pin
Batch: M14520

10.0	MS203923C21	Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Pin
Batch: M104156

11.0	R 3400	plastic tubing 1/4id x 3/8od-black
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Comment: Qty.: 3.0500 f(s)/Unit Total: 6.1000 f(s)
plastic tubing 1/4id x 3/8od-black
Cut to 18" Long X2 measured 8/12/02
Batch: 109886

12.0	41232 200 006 001	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bracket
Batch: 30505

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation: Description :

13.0 41232 200 005 001 Spacer (Step Actuator)



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)
Spacer (Step Actuator)
Batch: 43253

14.0 41232 200 004 001 Reducer Tee Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Reducer Tee Assembly
Batch: 31779

15.0 41232 200 003 001 Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Spring (Step Actuator)
Batch: 30941

16.0 41232 200 001 001 Step Actuator LH Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Step Actuator LH
Batch: B 43286

17.0 124K002 4CR 0545 Hose ass'y-Step Actuator



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Hose ass'y-Step Actuator
BATCH: 104042

18.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location: 10

PPP Rev: B

9/1/30

56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.06.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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REVISION				
LETTER	DRFTSMAN	DATE	DESCRIPTION	APPROVED DATE
A	DNN	1/14/04	INCRP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	1/14/04

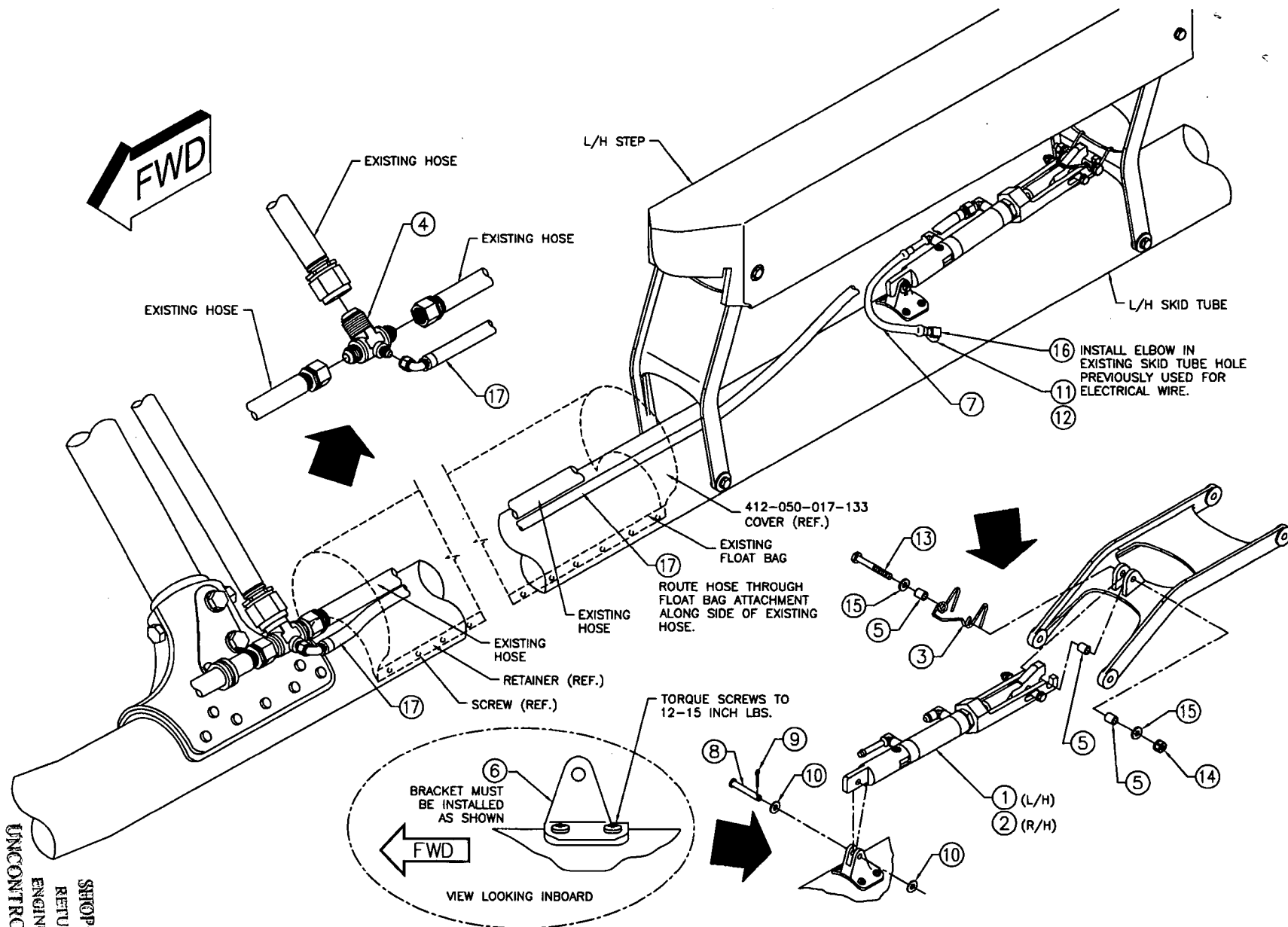
1	1	17	PS4025E000DF540A	HOSE																																									
1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634																																								
2	2	15	AN960JD416	WASHER																																									
1	1	14	MS21042-L4	NUT																																									
1	1	13	AN4-23A	BOLT																																									
AR	AR	12	MIL-S-8802	SEALANT																																									
1	1	11	MS35489-93	GROMMET																																									
2	2	10	AN960JD416L	WASHER																																									
1	1	9	MS24665-151	COTTER PIN																																									
1	1	8	MS20392-3C21	PIN																																									
2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309																																								
1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)																																								
3	3	5	41232-200-005-001	SPACER																																									
1	1	4	41232-200-004-001	REDUCER TEE																																									
1	1	3	41232-200-003-001	SPRING																																									
1		2	41232-200-001-002	R/H ACTUATOR ASSY																																									
	1	1	41232-200-001-001	L/H ACTUATOR ASSY																																									
			-002	R/H INSTALLATION																																									
			-001	L/H INSTALLATION																																									
			-002	-001	FWD NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE																																		
NO. REQ'D PER ASSY																																													
LIST OF MATERIAL																																													
<table border="1"> <tr> <td rowspan="4"> PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROPRIETARY TO ERM ANTON, INC. NO DISSEMINATION, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSES IS FORNED WITHOUT AUTHORIZATION FROM ERM ANTON, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS. </td> <td rowspan="4"> UNLESS OTHERWISE SPECIFIED X±.1 X0L±.03 X00L±.010 ANGLES ±.1° </td> <td>DRFTSMAN</td> <td>D. NELSON</td> <td>5/20/02</td> <td rowspan="4"> TITLE STEP ACTUATOR INSTALLATION </td> </tr> <tr> <td>CHECK</td> <td>D. MURPHY</td> <td>5/20/02</td> </tr> <tr> <td>STRESS</td> <td></td> <td></td> </tr> <tr> <td>PROL. ENGR.</td> <td></td> <td></td> </tr> <tr> <td colspan="2">41232-1000</td> <td>HEAT TREAT</td> <td colspan="2"></td> <td>DWG. SIZE</td> <td>C</td> <td>SCALE</td> <td>NONE</td> </tr> <tr> <td colspan="2">NEXT ASSEMBLY</td> <td>FINISH</td> <td colspan="2">Erm Anton, Inc.</td> <td>DWG. NO.</td> <td>41232-000-001</td> <td>SHT 1 OF 2</td> <td>REV.</td> <td>A</td> </tr> </table>												PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROPRIETARY TO ERM ANTON, INC. NO DISSEMINATION, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSES IS FORNED WITHOUT AUTHORIZATION FROM ERM ANTON, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.	UNLESS OTHERWISE SPECIFIED X±.1 X0L±.03 X00L±.010 ANGLES ±.1°	DRFTSMAN	D. NELSON	5/20/02	TITLE STEP ACTUATOR INSTALLATION	CHECK	D. MURPHY	5/20/02	STRESS			PROL. ENGR.			41232-1000		HEAT TREAT			DWG. SIZE	C	SCALE	NONE	NEXT ASSEMBLY		FINISH	Erm Anton, Inc.		DWG. NO.	41232-000-001	SHT 1 OF 2	REV.	A
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SHOP COPY
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 WITHOUT NOTICE
 WORK ORDER
 NO. 43267

NO. 42007
WORK ORDER

WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

001 L/H INSTALLATION (SHOWN)
002 R/H INSTALLATION (OPPOSITE)



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Era Aviation, Inc.

STEP ACTUATOR INSTALLATION

SIZE
C

DATE
41232-000-001

SHT 2 OF 2

REV.
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